

74985

Page 1.

N900040100

Setup Start ***NS1***

Stop ***NS2***

20

Cust Item ID:

20

Customer:

Run Start *NR1*

Date: 11/10/14

Tooling:**Date:**

QC: _____

Date:

SPC (Y/N):

Date:

Stop *NR2*

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74985

74985

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October-14-11 10:31:32 AM

Item ID: D2873-045 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Nut Plate Assembly
 Start Date: 14/10/2011 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 28/10/2011 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		SL 11-10-21					
140 *140* Small Fab Small Fab	Small Fab Memo 1-Deburr 2- C'sink as per Dwg D2873	0.00 0.00							
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		Schulze					

EP 11/10/24 (20)

*counters
(r2c)*

W/O:		WORK ORDER CHANGES						
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Work Order ID 74985

74985

Page 4

October-14-11 10:31:32 AM

Item ID: D2873-045 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Nut Plate Assembly
 Start Date: 14/10/2011 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 28/10/2011 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							<i>11-10-31 (20)</i>
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <i>2 tube</i> <i>copy</i> Memo	0.00 0.00							<i>RT 11-11-01 (x20)</i>
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>11/11/02</i> <i>MF 11-11-01</i>

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

October-14-11 10:31:38 AM

Page 1

Work Order ID: 74985

74985

Parent Item: D2873-045

D2873-045

Parent Item Name: Nut Plate Assembly

Start Date: 14/10/2011

Required Date: 28/10/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS21075L5 Purchased No

MS21075L5

Nut Plate

Location

Loc Qty

Loc Code

ST303

26

116914

1

118542

25

M6061T6B0.375X01.00

Purchased

No

180

f

24.7600

0.225

4.736842

0

M6061T6B0.375X01.000

6061T6 BAR .375 x 1.00

Location

Loc Qty

Loc Code

MAT

24.76

113325

0

118641

24.76

MS20426AD4-6

Purchased

No

180

Each

561.0000

4

80

MS20426AD4-6

Rivet

Location

Loc Qty

Loc Code

GA

154

118510

154

ST317

407

110139

201

117505

206

**

**

**

Handwritten: 4.74 11/10/31

Handwritten: 1117414 (40x)

Handwritten: 4.74 80 11.10.19 11/10/31

Handwritten: 80

Dart Aerospace Ltd

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Dart Aerospace Ltd

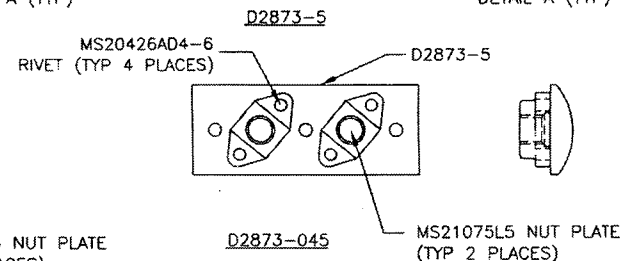
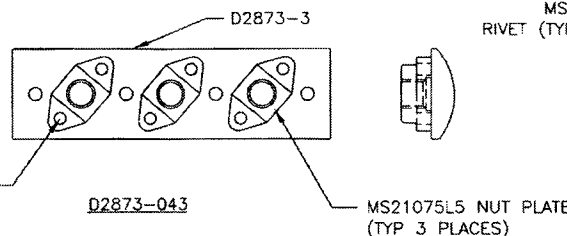
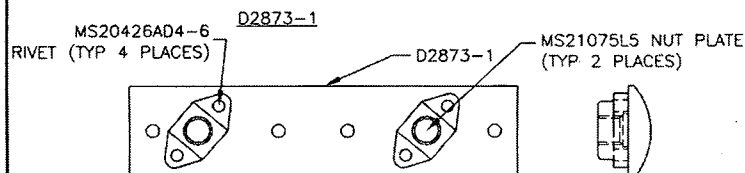
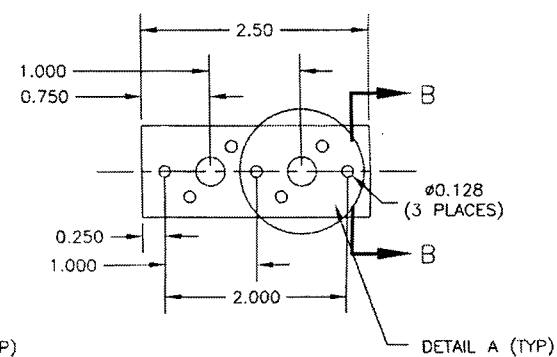
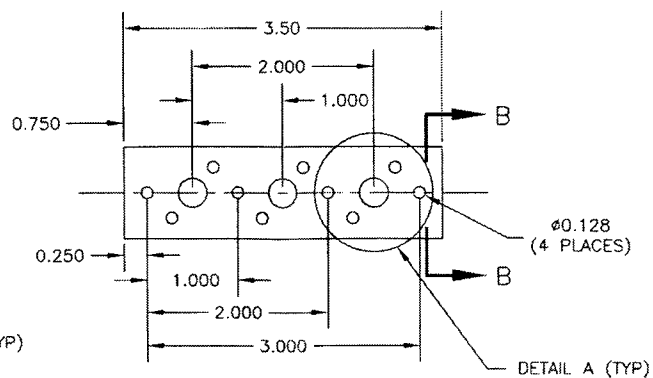
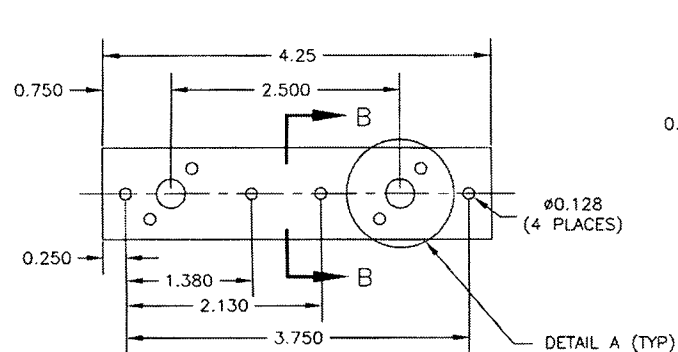
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D2873-1/-3/-5 RADIUS BLOCK

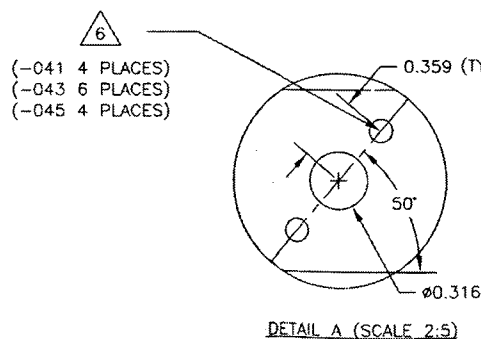
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X0.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100'

D2873-041/-043/-045 NUT PLATE ASSEMBLY

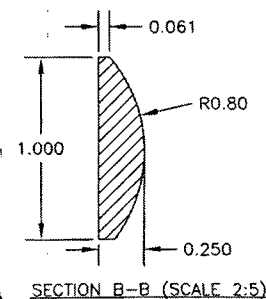
- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



SHOP
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34985
M.C.J.



A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE LTD HARRISBURG, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2873
DATE 05.07.26	TITLE RADIUS BLOCK	REV. A SHEET 1 OF 1 SCALE 4:5

RELEASED
05.07.26

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